

Work Order ID 81372

Wednesday, March 14, 2012 10:28:47 AM

81372*April 2nd*

Page 1

Item ID: D4030-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *ME*Date: *12-03-14*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	C

100	Pick Kit	0.00
-----	----------	------

100

Packaging

Memo

0.00

Packaging

12/3/27

110	Assemble as per dwg	0.00
-----	---------------------	------

110

HandFinish

Memo

0.00

Hand Finishing

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****

1 12/3-28

120	QC5- Inspect part completeness to step on W/O	0.00
-----	-----------------------------------------------	------

120

QC

Memo

0.00

Quality Control

5/12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81372

Wednesday, March 14, 2012 10:28:47 AM

81372

Page 2

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 3/14/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	PPD	81369		2/3/29			WSP
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/2 [Signature]

1203-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 10:28:45 AM

Page 1

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC
IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-210 Placard, Max Load	200	Manufactured	No				Each	5.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST122		4							
				66275		1							
				76298		3							
				ST124		1							
				64869		1							
D2530 Handle Weldment		Manufactured	No			100	Each	9.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST506		9							
				77030		3							
				78965		6							
D2535 Spring		Manufactured	No			100	Each	44.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST504		44							
				77488		44							
D2537 Bushing		Manufactured	No			100	Each	34.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST504		34							
				77055		34							
D3913-041 Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
D3914-041 Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			

72051

BL 12-3-28

BL 12-3-28

61377

81379

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 10:28:46 AM

Page 2

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No 100 Each 19.0000
Washer

Location Loc Qty Loc Code

ST070 19
76956 4
80598 15

D3953-3 Manufactured No 100 Each 26.0000
Gas Spring Stud, Lid

Location Loc Qty Loc Code

ST075 26
76659 6
78042 20

D3953-7 Manufactured No 100 Each 14.0000
Spring Spacer

Location Loc Qty Loc Code

ST075 14
76295 14

D3953-9 Manufactured No 100 Each 18.0000
Gas Spring Washer

Location Loc Qty Loc Code

ST075 18
78916 18

D3953-17 Manufactured No 100 Each 7.0000
Gas Spring Spacer

Location Loc Qty Loc Code

ST075 7
76294 7

D3953-19 Manufactured No 100 Each 14.0000
Gas Spring Bracket

Location Loc Qty Loc Code

ST075 14
75227 14

6 42 65 SP
2 2 SP
2 2
2 2
2 2
2 2
1 1
1

Wednesday, March 14, 2012 10:28:46 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 3

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-21 Manufactured No 100 Each 1.0000
Gas Spring Bracket

1 8/20/12

Location Loc Qty Loc Code

ST075 1
73557 1

D3969-3 Manufactured No 100 Each 15.0000
Spring (Basket Lid)

1 1

Location Loc Qty Loc Code

ST272 15
64285 1
73515 14

AN3-14A Purchased No 100 Each 96.0000
Bolt

4 4

Location Loc Qty Loc Code

ST352 96
119328 96

AN3-16A Purchased No 100 Each 137.0000
Bolt

2 2

Location Loc Qty Loc Code

ST352 137
117441 49
118628 38
120986 50

AN5-17A Purchased No 100 Each 84.0000
Bolt

4 4/23/12

Location Loc Qty Loc Code

ST338 84
117872 42
120498 42

4

Wednesday, March 14, 2012 10:28:46 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, March 14, 2012 10:28:46 AM

Page 4

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 89.0000

3 3

Bolt

Location

Loc Qty

Loc Code

ST357

89

118626

14

119775

25

120986

50

AN310-4 Purchased No

100 Each 75.0000

3 3

NUT

Location

Loc Qty

Loc Code

ST344

75

120124

25

120518

25

121011

25

AN310C4 Purchased No

100 Each 49.0000

2 2

Nut

Location

Loc Qty

Loc Code

ST344

49

119324

19

120360

30

MS21042L3 Purchased No

100 Each 3,192.0000

6 12/3/25 6

Nut

Location

Loc Qty

Loc Code

ST300

3192

117441

16

117885

32

118451

5

118927

3

119017

2956

119075

180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, March 14, 2012 10:28:46 AM

Page 5

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,610.0000

4

4

Nut

Location

Loc Qty

Loc Code

ST300

1610

116105

5

116548

43

117611

42

118179

20

119109

1500

MS24665-151

Purchased

No

100

Each

315.0000

3

3

Cotter Pin

Location

Loc Qty

Loc Code

ST309

315

17566

315

MS24665-300

Purchased

No

100

Each

210.0000

2

2

Cotter Pin

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

10

116823

10

NAS1149F0432P

Purchased

No

100

Each

298.0000

6

Washer

Location

Loc Qty

Loc Code

ST275

298

118840

32

119307

64

120142

2

120360

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, March 14, 2012 10:28:46 AM

Page 6

Work Order ID: 81372

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

93.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST275

93

117735

93

NAS1149F0332P

Purchased

No

100

Each

782.0000

8

8

WASHER

Location

Loc Qty

Loc Code

ST275

782

117735

37

119225

142

120498

200

120910

200

120986

200

17317

3

NAS1149C0432R

Purchased

No

100

Each

2,618.0000

2

Washer

Location

Loc Qty

Loc Code

ST297

2618

117291

1618

119124

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

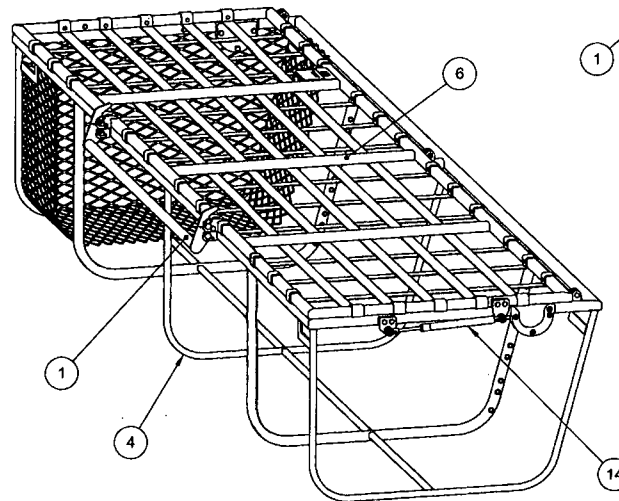
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

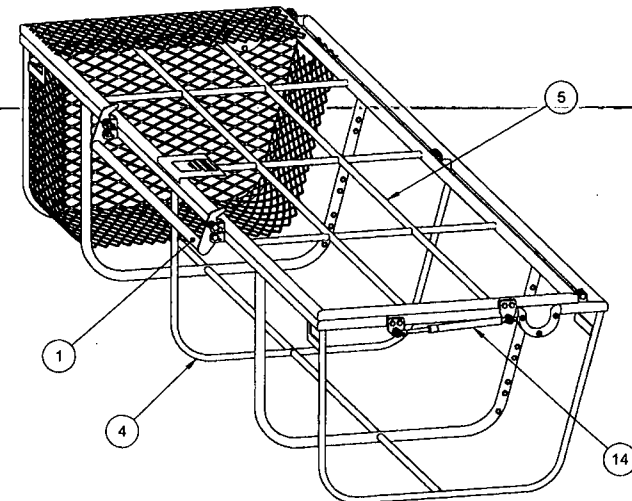
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

81372

RELEASED
10.08.12
ECN 10-596

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGN		
DRAWN	DRAWN		
CHECKED	CHECKED		
MFG. APPR.	MFG. APPR.		
APPROVED	APPROVED		
DE APPR.	DE APPR.		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

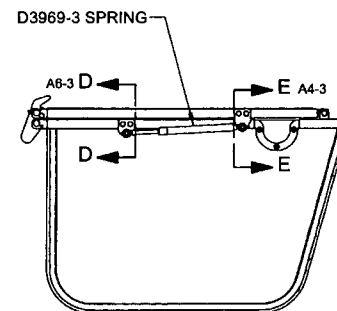
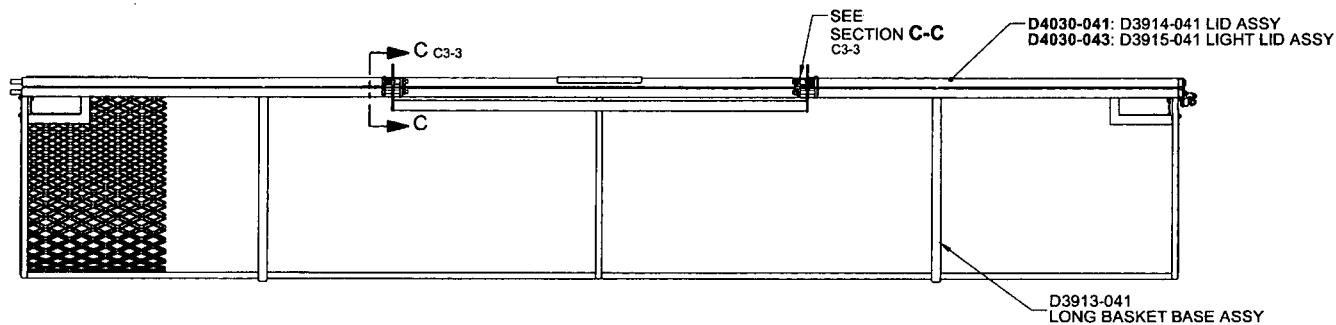
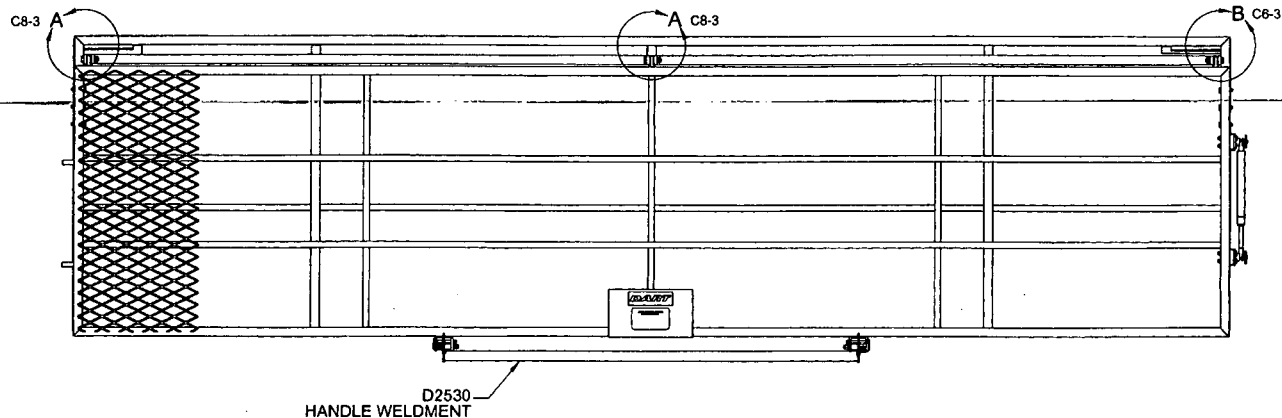
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

81372

RELEASED
10.08.12

DESIGN	145	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SEF	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350) — NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

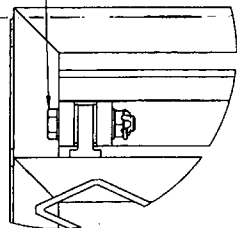
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

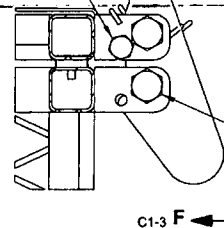
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

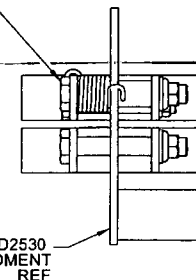
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

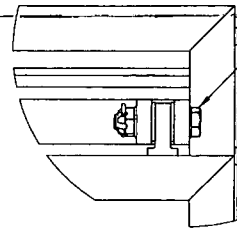
D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

81372

RELEASED
10.08.12

DESIGN	415	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JRS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries